

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027260**Date Inspected:** 28-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

At the start of the shift this Quality Assurance Lead Inspector (QAI) traveled to the SAS project site and observed the work and the inspection performed by American Bridge/Fluor Enterprises (AB/F) Quality Control (QC) personnel. The observations and inspections were performed as noted below:

A). This Quality Assurance Lead Inspector (QALI) assigned the QA Inspectors to the following, but not limited to the work station(s) listed , to observe the welding and the QC inspection of the following:

Joselito Lizardo-Tower, at the 9 Meter (Observed the welding, QC inspection and testing of diaphragm plates and fit-up of the drop-in plates).

Ken Riley-OBG W13 (Observation of welding and QC inspection of vent holes and lifting lug holes) and OBG W12/W13 and W13/W14 field splices (Observation of fit-up and QC inspection of stiffener plates @ longitudinal stiffeners, See Summary of Conversations).

Doug Frey-OBG W13 (Observation of QC inspection and testing of lifting lug holes), OBG W5, Deck Access Hole (Observation of welding and QC inspection of the deck access hole identified as "5W-PP29.5-W2), welding of utility pipe systems (FW Spencer) and QA/NDE verification.

Skyway-No work

NOTE: See QA daily Weld Inspection Reports (WIR) and NDE reports for additional information and details.

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## WELDING INSPECTION REPORT

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### Quality Assurance Lead Inspector (QALI) Summary

This QA Lead Inspector (QALI) observed the QA Inspector's Joselito Lizardo, Ken Riley and Doug Frey monitor the work performed by the QC inspectors at random intervals and also observed the QA Inspectors verify the welding parameters, the minimum preheat and the maximum interpass temperatures for compliance with the contract specifications. The QAI's utilized a Fluke 337 clamp meter to measure the electrical welding parameters, Tempil Heat Indicators and/or a Fluke 63 IR Thermometer for verifying the preheat and interpass temperatures. At the conclusion of the shift, this QA Lead Inspector discussed and reviewed the work performed by the QAI's in regards to the various observations and the verifications of the WPS's, consumables, welding parameters, preheat and interpass temperatures. The QAI observations of the QC inspection and verification of the welding parameters performed on this date appeared to comply with the contract specifications and no issues were noted.

This QALI continued the daily review of field inspection reports and update of the field document control tracking records regarding the Orthotropic Box Girders (OBG, Longitudinal and Transverse "A" Deck Stiffeners, Deck Access Holes and the Tower Shear plates).

### Summary of Conversations:

There were general conversations with Quality Control Lead Inspector, Bonifacio Daquinag, Jr., at the start of the shift regarding the location of welding, inspection personnel scheduled for this shift.

In conversation with QAI Ken Riley, this QAI was informed that the contractor did not have an approved Welding Procedure Specification (WPS) in regards to the welding of the horizontal stiffeners which are attached to the longitudinal "A" deck stiffeners located at the OBG field splices identified as W12/W13 and W13/W14. Mr. Riley also indicated to this QAI that he had spoken to the QC Lead Inspector, Bonifacio Daquinag, regarding this issue and Mr. Daquinag expressed that a Non-Conformance Report (NCR) would be generated if the welding commence prior to approval.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Reyes,Danny	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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